

Date: Thursday, 5/31/2007 7:23:36 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32720 -1
Estimate Number : 12577
P.O. Number : *N/A*
This Issue : 5/31/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : LARGE FAB ASSY
Previous Run : 31445
Written By : *JA 07.05.31*
Checked & Approved By : *JA 07.05.31*
Comment : Est Rev:A New Issue 06-11-09 JLM

Drawing Name : STEP WELDMENT
Part Number : D3562042
Drawing Number : D3562 UNDER REVIEW
Project Number : N/A
Drawing Revision : A
Material : *N/A*
Due Date : 6/11/2007

EFFECTIVE *07.05.31* AUTH *u*
RELEASED _____ DATE _____
split
Qty: *4* Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<i>B31984</i>

B31984

Check Material for any Dents or Defects

FF 07-06-12
LE 07-06-04

2.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:
Qty Part Number Description Batch
2 D2734 End Cap *B30883*

LE 07-06-04

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

3-Weld (1)end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod *M102756*

4-Grind end cap welds flush as per Dwg D3562

FF 07-06-12
a.m 07/06/04 LE (5)
FF 07-06-12
LE 07-06-07

LE 07-06-07

FF 07/06/07

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32720

Part Number: D3562042

Job Number:

Seq. #:

Machine Or Operation:

Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill Rivet holes as per dwg D3562. USING DT 8956

INSPECT WORK TO CURRENT STEP

QC5

Comment: INSPECT WORK TO CURRENT STEP

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

QC3

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D3560041

ARM WELDMENT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

10.0

D3560043

ARM WELDMENT

Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

ARM WELDMENT

Batch: 332645

11.0

MS20600AD4W5

Blind Rivet

Comment: Qty.: 36.0000 Each(s)/Unit Total: 180.0000 Each(s) SEE W/D CHANGE

Blind Rivet

batch: m8953

24 m 1209 =

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32720

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet legs using Magnabond as per dwg D3562.

Ensure to wipe off any excess magnabond of the step

A/R Magnabond 6398

Batch:

M104723

04-2008

FF 07-06-14

4

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Remaining end cap as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M102756

2-Grind end cap welds flush as per Dwg D3562

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch:

M104281

M-L

07/06/15

Thursday, 5/31/2007 7:23:37 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 32720

Part Number: D3562042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-06-18

20.0

PACKAGING 1

PACKAGING RESOURCE #1



SEE W/O CHANGE FOR
STEP 17.5



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

07/06/19
07-06-19

Job Completion



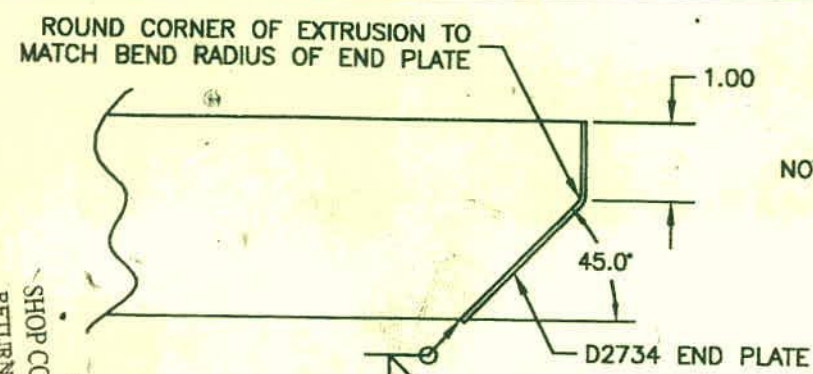
POSITIVE RECALL

EFFECTIVE _____ AUTH _____
RELEASED U DATE 07-06-19

DART

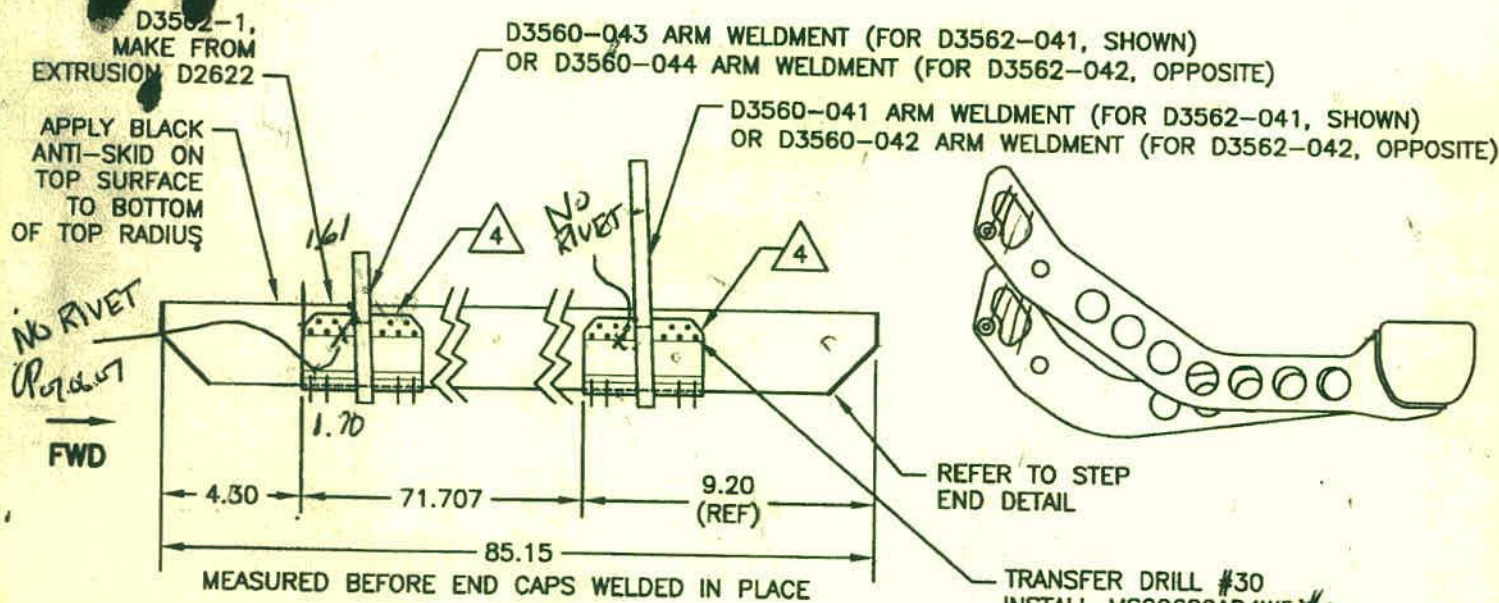
RELEASED
01.01.2006

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32720



D3562-041 LH STEP ASSEMBLY (SHOWN)
D3562-042 RH STEP ASSEMBLY (OPPOSITE)

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELD PER DART QSI 004
- 3) FINISH:
AFTER WELDING END PLATES AND PRIOR TO DRILLING/INSTALLING ARM WELDMENTS:
i) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
ii) POWDER COAT GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) INSTALL ARM WELDMENTS WITH A LAYER OF SIKAFLEX-241/201 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN THE ARM WELDMENT AND STEP EXTRUSION
- 5) ALL DIMENSIONS ARE IN INCHES

TRANSFER DRILL #30
INSTALL MS20600AD4W5 RIVET (36 PLACES)
DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING, TOUCH-UP RIVET HEADS WITH PAINT PER DART QSI 005 4.2

MAGNABOND
07.06.07 EMAIL

DESIGN	DRAWN BY	DART AEROSPACE LTD
07.01.15	06.09.26	NEW ISSUE
07.01.15	ARMS NOW RIVETED TO STEP	
CHECKED	APPROVED	DRAWING NO. D3562
DATE	TITLE	STEP ASSEMBLY
A	06.09.26	NEW ISSUE
B	07.01.15	ARMS NOW RIVETED TO STEP
REV. B	SHEET 1 OF 1	SCALE NTS

